

Date: Wednesday, 4/5/2006 3:33:36 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 412 WEB
 Job Number : 26589
 Estimate Number : 10466
 P.O. Number : N/A Part Number : D33891
 This Issue : 4/5/2006 S.O. No. : N/A Drawing Number : D3389 REV C
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : LANDING GEAR Drawing Revision : C
 Previous Run : 26537 Material : N/A
 Due Date : 4/24/2006 Qty: 6 Um: Each
 Written By : SEE COMMENT BELOW
 Checked & Approved By : 06.04.06
 Comment : Est Rev:A 05.08.31 New issue KJ/JLM
 Est Rev:B 06-02-08 As per Rev C JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D25003100 Ext'n - 'I' Beam Web 4"



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Ext'n - 'I' Beam Web 4"

Pick:

Qty	Part Number	Description	Batch
1	D2500-3-100	Web Extrusion	619074 IT 06-04-07

2.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Cut to length as per Dwg D3389 IT 06-04-07 (6)

2-Drill pilot holes using DT8785 as per Dwg D3389 IT 06-04-07 (6)

3-Open 1X .257" Dia Hole IT 06-04-07 (6)

4-Open Remaining holes to finish size as per Dwg D3389 IT 06-04-07 (6)

5-Deburr IT 06-04-07 (6)

3.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

BE 06-04-07 (6)

4.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

IT 06-04-10 (6)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DD Date: 26/04/14
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 4/5/2006 3:33:36 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 412 WEB

Job Number: 26589

Part Number: D33891

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BE 06-04-11 (6)

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: LG RT 06-04-11 (6)

7.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

RT 06/04/11 (6)

Job Completion



U 06-04-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

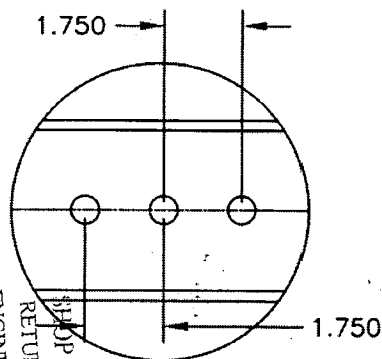
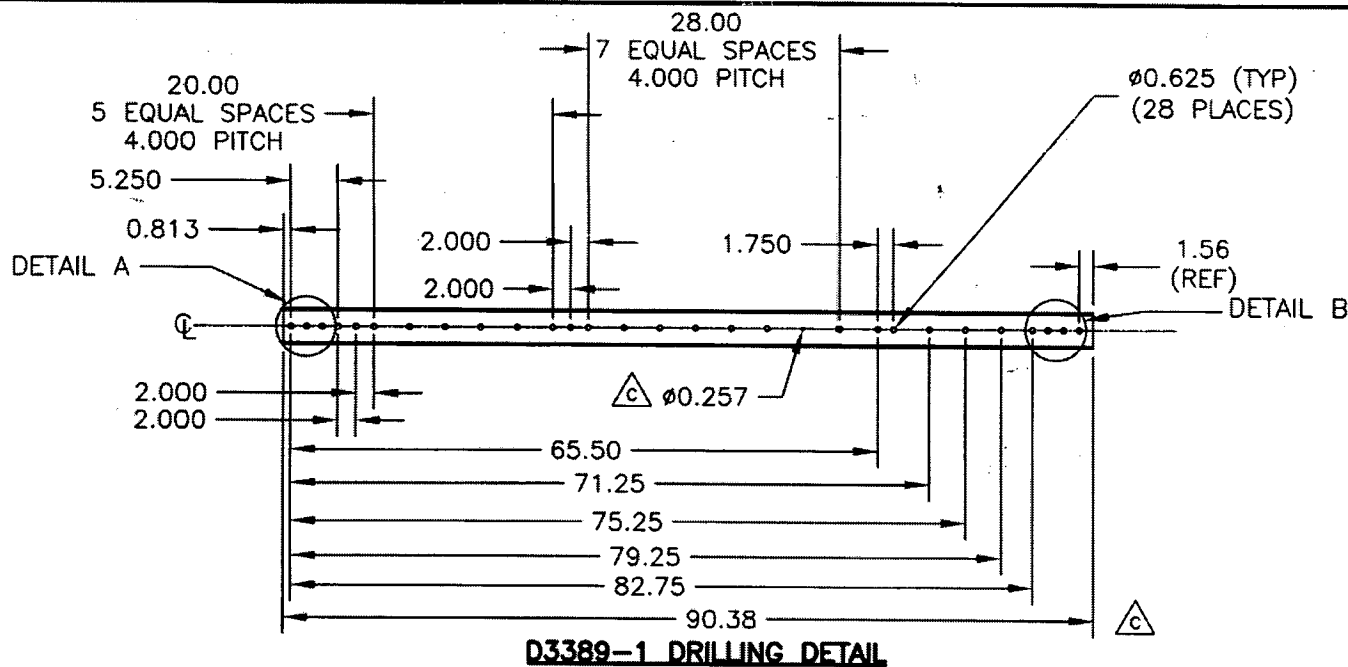
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

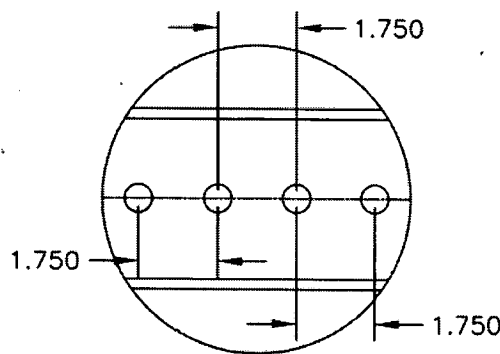
NOTE: Date & initial all entries

RELEASE

DESIGN	DRAWN BY		DART AEROSPACE USA, INC.	
PH	PH		PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.		REV. C
<i>[Signature]</i>	<i>[Signature]</i>	D3389		SHEET 1 OF 1
DATE		TITLE		SCALE
06.01.23		412 WEB		1:20
A	05.02.07		NEW ISSUE	
B	05.06.13		UPDATE DIMENSIONING	
C	06.01.23		DECREASE OVERALL LENGTH, MODIFY HOLE	



DETAIL A
(SCALE 1:4)



DETAIL B
(SCALE 1:4)

ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 26589

D3389-1 412 WEB

- 1) MATERIAL: MAKE FROM D2500-3 EXTRUSION
- 2) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

Copyright © 2005 by DART AEROSPACE USA, INC.

